DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-015975
Date Inspected: 02-Aug-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Li Yang and Zhu Zhong Hai

Inspected CWI report:	☐	**Yes**	☐	**No**	☑	**N/A**		
Electrode to specification:	☑	**Yes**	☐	**No**	☐	**N/A**		
Qualified Welders:	☑	**Yes**	☐	**No**	☐	**N/A**		
Approved Drawings:	☑	**Yes**	☐	**No**	☐	**N/A**		

CWI Present:	☑	**Yes**	☐	**No**				
Rod Oven in Use:	☑	**Yes**	☐	**No**	☐	**N/A**		
Weld Procedures Followed:	☑	**Yes**	☐	**No**	☐	**N/A**		
Verified Joint Fit-up:	☐	**Yes**	☑	**No**	☐	**N/A**		
Approved WPS:	☑	**Yes**	☐	**No**	☐	**N/A**		
Delayed / Cancelled:	☐	**Yes**	☑	**No**	☐	**N/A**		

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 9AE

This QA Inspector verified and checked the snug tightening for the bolts installed at Corner Assembly at cross truss post and vertical truss post on random basis along with ZPMC QC Mr. Zhang Hai Jung for Segment 9AE at the Cross Beam and Bike Path side at Panel Points (PP) 72 and PP 73. The QA Inspector observed the results appeared to be in general compliance.

The bolt sizes used were M22 x 85, M22 x 55, M24 x 60, M24 x 65 and M24 x 80. Please reference the pictures attached for more comprehensive details.

Segment 9BE

This QA Inspector verified and checked the snug tightening for the bolts installed at Corner Assembly at cross truss post and vertical truss post on random basis along with ZPMC QC Mr. Zhang Hai Jung for Segment 9BE at

the Cross Beam and Bike Path side at Panel Points (PP) 74, PP 75 and PP 76. The QA Inspector observed the results appeared to be in general compliance.

The bolt sizes used were M22 x 85, M22 x 55, M24 x 60, M24 x 65 and M24 x 80. Please reference the pictures attached for more comprehensive details.

Traveler Rail Bracket

This QA Inspector observed the in process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as TR6B-PP72-004. The welder identification was 204342 and was observed welding in the 1G (Flat) and 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2231-Tc-U4C-F and WPS-B-T-2231-Tc-U4C-F. The piece mark was identified as the Traveler Rail Bracket.

Segment 9CW to Segment 9DW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBW9C-003. The welder identification was 067765, 066038 and 067642 and was observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1. The piece mark was identified as the Bottom Panel, transverse splice weld. Please reference the pictures attached for more comprehensive details.

Traveler Rail Bracket

This QA Inspector observed the in process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as TR6B-PP77-004. The welder identification was 222369 and was observed welding in the 1G (Flat) and 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2231-Tc-U4C-F and WPS-B-T-2231-Tc-U4C-F. The piece mark was identified as the Traveler Rail Bracket.

Segment 9CE to Segment 9DE

This QA Inspector observed the in process fillet weld repair welding by Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as DP711A-001-011/012. The welder identification was 067765 and observed welding in the 4F (Overhead) position using approved Welding Procedure Specification WPS-B-T-4114-1. The piece mark was identified as Deck Panel, I-Rib hold back area.

Traveler Rail Bracket

This QA Inspector observed the in process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as TR6B-PP78-004. The welder identification was 222369 and was observed welding in the 1G (Flat) and 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2231-Tc-U4C-F and WPS-B-T-2231-Tc-U4C-F. The piece mark was identified as the Traveler Rail Bracket. Please reference the pictures attached for more comprehensive details.

Segment 9DW to Segment 9EW

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as OBW9C-006. The welder identification was 067609 and was observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1. The piece mark was identified as the Edge Panel, Counter Weight side.

Traveler Rail Bracket

This QA Inspector observed the in process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as TR6B-PP74-004. The welder identification was 220069 and was observed welding in the 1G (Flat) and 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2231-Tc-U4C-F and WPS-B-T-2231-Tc-U4C-F. The piece mark was identified as the Traveler Rail Bracket.

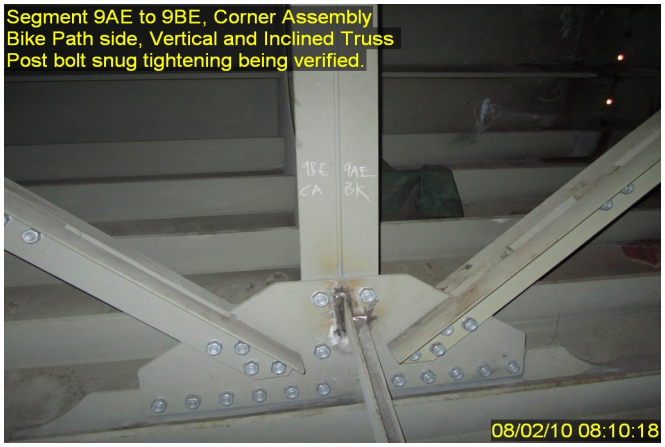
Traveler Rail Bracket

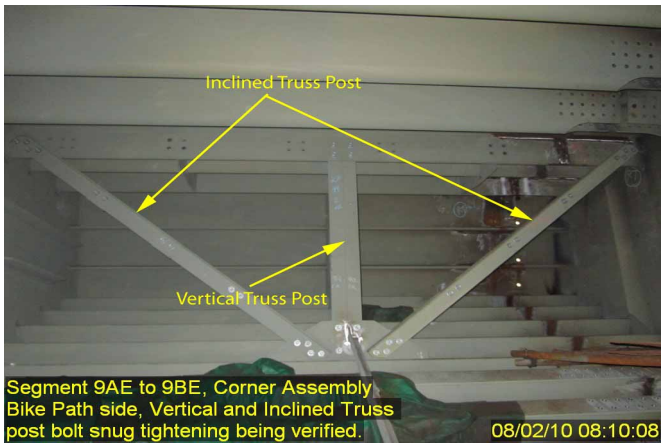
This QA Inspector observed the in process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as TR6B-PP73-004 and TR6B-PP79-004. The welder identification was 220069 and was observed welding in the 1G (Flat) and 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2231-Tc-U4C-F and WPS-B-T-2231-Tc-U4C-F. The piece mark was identified as the Traveler Rail Bracket.

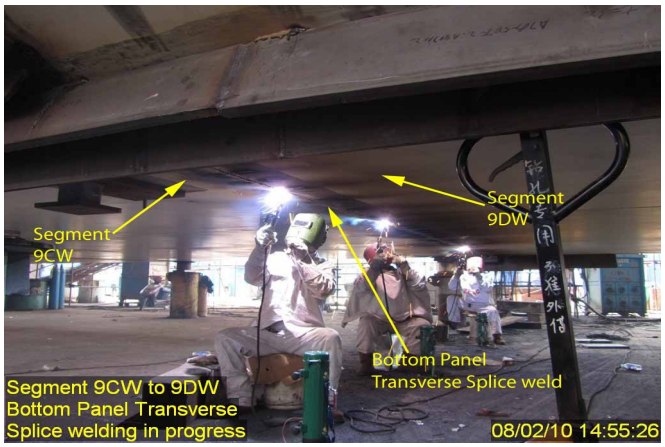
Segment 9CW to Segment 9DW

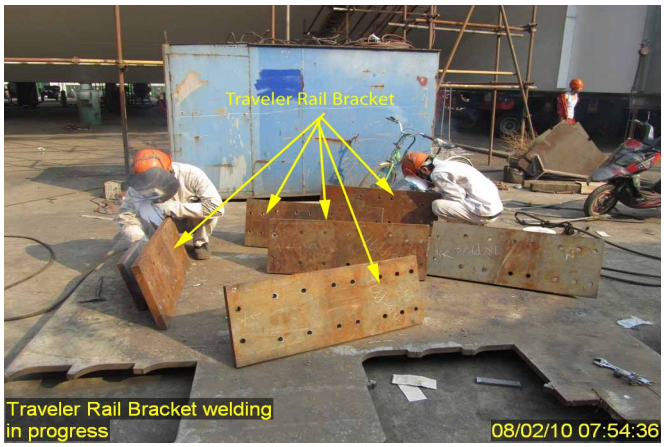
This QA Inspector observed the in process fillet welding operation by the Flux Cored Arc Welding (FCAW) process. The Weld joint was designated as SP732-001-11, SP732-001-12, SP732-001-13, SP732-001-14, SP732-001-15 and SP732-001-16. The welder identification was 040704 and was observed welding in the 2F (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2132. The piece mark was identified as the Side Panel T-Ribs, Cross Beam side.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.









Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 5 of 5)

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer